

Work Order ID 57822

April 16, 2010 10:48:52 AM



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Item ID: D3911-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Installation Stud, Lower



Cust Item ID:

Start Date: 16/04/2010 Start Qty: 6.00

Customer:

Required Date: 29/04/2010 Req'd Qty: 6.00

Reference: *Prod 10.04.16*

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description |
|--------------------------------|--------------------------|
|--------------------------------|--------------------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|-------|---|
| D3911 | C |
|-------|---|

110



Doosan

Doosan Lathe

Memo

I-Mill as per folio FA831 & dwg,
 FOLIO REV: N/A
 DWG REV: C

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

0.00

SL 10/04/17
(6)

120



QC2- Inspect parts off machine FAI/FAIB

0.00

SL 10/04/17
6 Ø

QC

Quality Control

Memo

0.00



The value adding parts of the process are obvious, so companies mistakenly focus on trying to make them go faster. The waste is not obvious, so it is not addressed. Lean focuses on eliminating the waste.

Lean is ongoing, there is no end to the search for waste!

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Item ID: D3911-1

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Start Date: 16/04/2010 Start Qty: 6.00

Required Date: 29/04/2010 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

Date:

QC:

Date:

Tooling:

Date:

SPC (Y/N):

Date:

Setup Start



Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Packaging

Packaging

Identify as per dwg & Stock Location: O95

0.00

0.00

0.00

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

0.00

PC 10/4/20 6

10/04/20 JJ

MF 10-4-20



7 deadly wastes

- 1. Overproduction***
- 2. Rework***
- 3. Transportation***
- 4. Inappropriate / over Processing***
- 5. Unnecessary Inventory***
- 6. Delays / Waiting***
- 7. Unnecessary Motions***

Picklist Print

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Work Order ID: 57822



Parent Item: D3911-1



Parent Item Name: Basket Installation Stud, Lower

Start Date: 16/04/2010

Required Date: 29/04/2010

Comments: IPP RevA: New issue DD verified by:EC

IPP

Start Qty: 6.00

Required Qty: 6.00

REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M303R1.000 | | Purchased | No | | | 110 | f | 45.2000 | 1.5789 | | | |



303 Round Bar 1.00

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |

Main Warehouse

| | |
|--------|------|
| MAT028 | 45.2 |
| 113325 | 45.2 |

1-6 SL 10/04/17



What is Waste

An activity or output that ***adds cost but does not add value*** as perceived by the end-use customer.

Elimination of waste - activities that utilize resources but do not create value must be eliminated. This is an ongoing hunt! Ideally it will involve all employees.

If you could explain to your customer what ***every step of*** your operation cost, are there any steps your customer would not be willing to pay for?

- scrap
- rework
- looking for: parts, tools, material, people, etc.
- rescheduling
- expedited shipments
- ??????????

| | | |
|--|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 57822 |
| Description: basket instl stud (lower) | Part Number: | D8911-1 |
| Inspection Dwg: D3911 Rev: C | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|-----------|-------------|-----------|---------------------|-----|
| Measured by: | <u>JL</u> | Audited by: | <u>DK</u> | Prototype Approval: | N/A |
| Date: | 10/04/17 | Date: | 10/04/17 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |



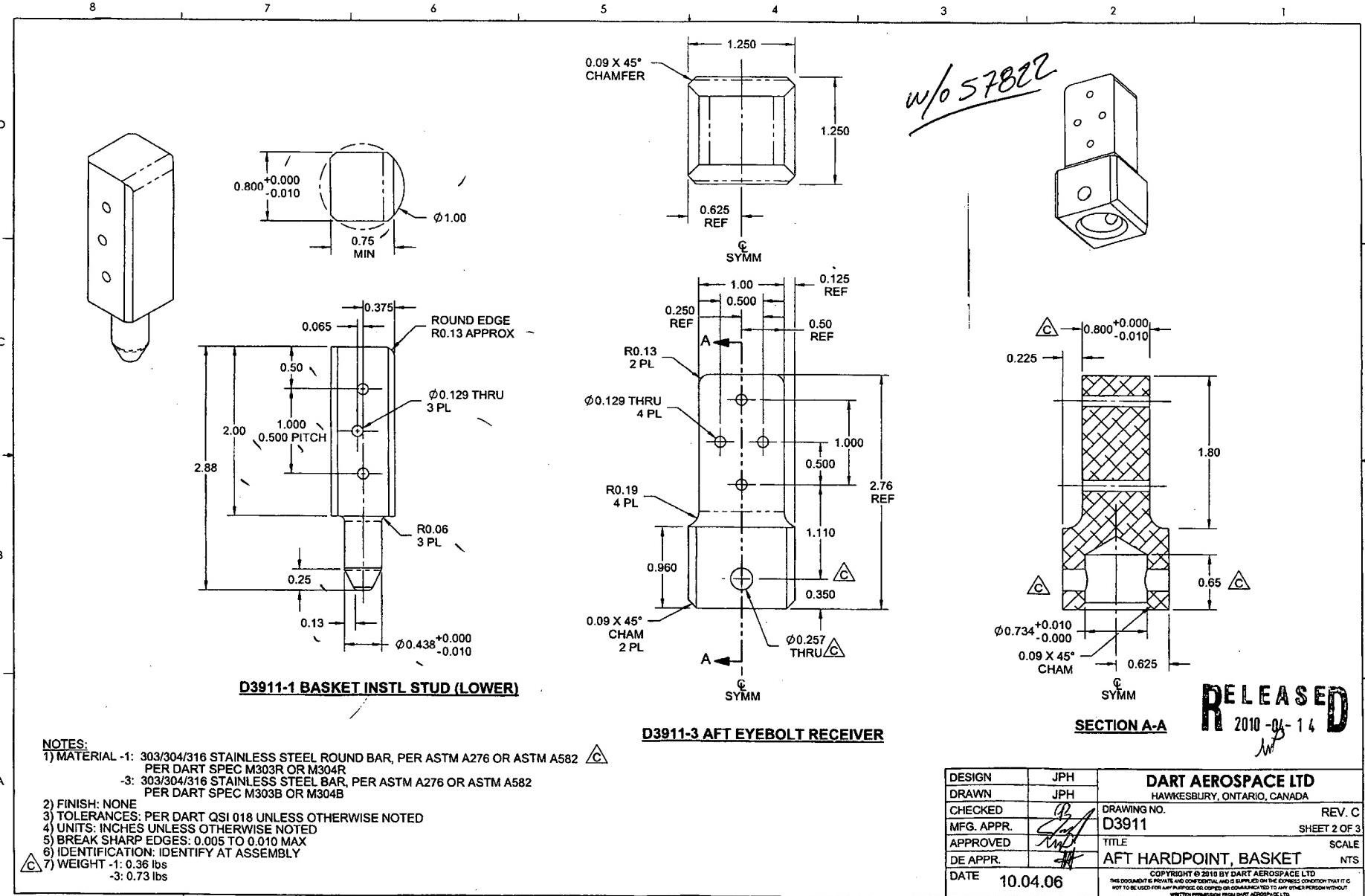
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- rescheduling
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- ??????????





Value stream mapping during kaizen
event.